

Date: Thursday, 12/14/2006 3:46:49 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 3"SKIDTUBE LIGHT "I" BEAM EXTRUSION
Job Number : 29985	
Estimate Number : 10306	
P.O. Number : N/A	Part Number : D26005108
This Issue : 12/14/2006 S.O. No. : N/A	Drawing Number : D2600 REV D1
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : PURCHASED PARTS	Drawing Revision : D1
Previous Run : 24410	Material : N/A
Written By : <u>HA 06/12/15</u>	Due Date : 1/15/2007 Qty: 115 Um: Each
Checked & Approved By : <u>HA 06/12/15</u>	
Comment : Est F 02/09/10 Added DSK 066 KJ/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

PG

PURCHASING

**Comment:** Issue P/O: 2722

- a) Extrude as per Dwg D2600
- b) Material: 6061-T6 (QQ-A-200/8)
- c) Minimum yield tensile strength = 35 ksi
- d) Minimum ultimate tensile strength = 40 ksi
- e) Minimum elongation = 8%
- f) Order at 108" long
- g) Caradon Indalex Tool # MS-18871
- h) To be packed per DSK 066
- i) Pull test to ASTM standard B221 required.
- j) Material certification is required

C 206112115

115

2.0

D26005108P

Extrusion 'I' Beam' thin

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 115.0000 Each(s)

EXTRUSION "I" BEAM THIN

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: Receive & Inspect For Transit Damage
 Ensure certification is attached

4.0

QC6

DIMENSIONAL CHECK

**Comment:** DIMENSIONAL CHECK

- 1-Inspect dimensions per Dwg D2600
- 2-Check Pull test per Dwg D2600 for compliance page attached.
- 3-Check hardness with Webster tester

HA 07/12/28 (15) 280

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 07/03/05

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 3"SKIDTUBE LIGHT "I" BEAM EXTRUSION

Job Number: 29985

Part Number: D26005108

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *in the shop*

JD 7-2-1

(280)

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(280)

Comment: FINAL INSPECTION/W/O RELEASE

207/03/05

Job Completion



CU 8/03/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2600	REV. 0 SHEET 1 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1
A	97.01.21	NEW ISSUE	
B	97.09.09	CHANGE MATERIAL SPEC.	
C	98.04.16	ADD D2600-3, UPDATE D2600-1 WIDTH, ADD DIE NO.	
D	98.08.20	INCREASE MIN. UTS TO 40 KSI	
DI	01.04.17	ADD PART NUMBERS & DIE NUMBERS <i>+GP</i>	

RELEASED
48.08.25 DS

GENERAL NOTES

1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi
MINIMUM ELONGATION = 8 %

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED
TO ASTM STANDARD B221 BY AN APPROVED TESTING
FACILITY TO ENSURE THAT THE BATCH MEETS THE
ABOVE MINIMUM MECHANICAL PROPERTIES.

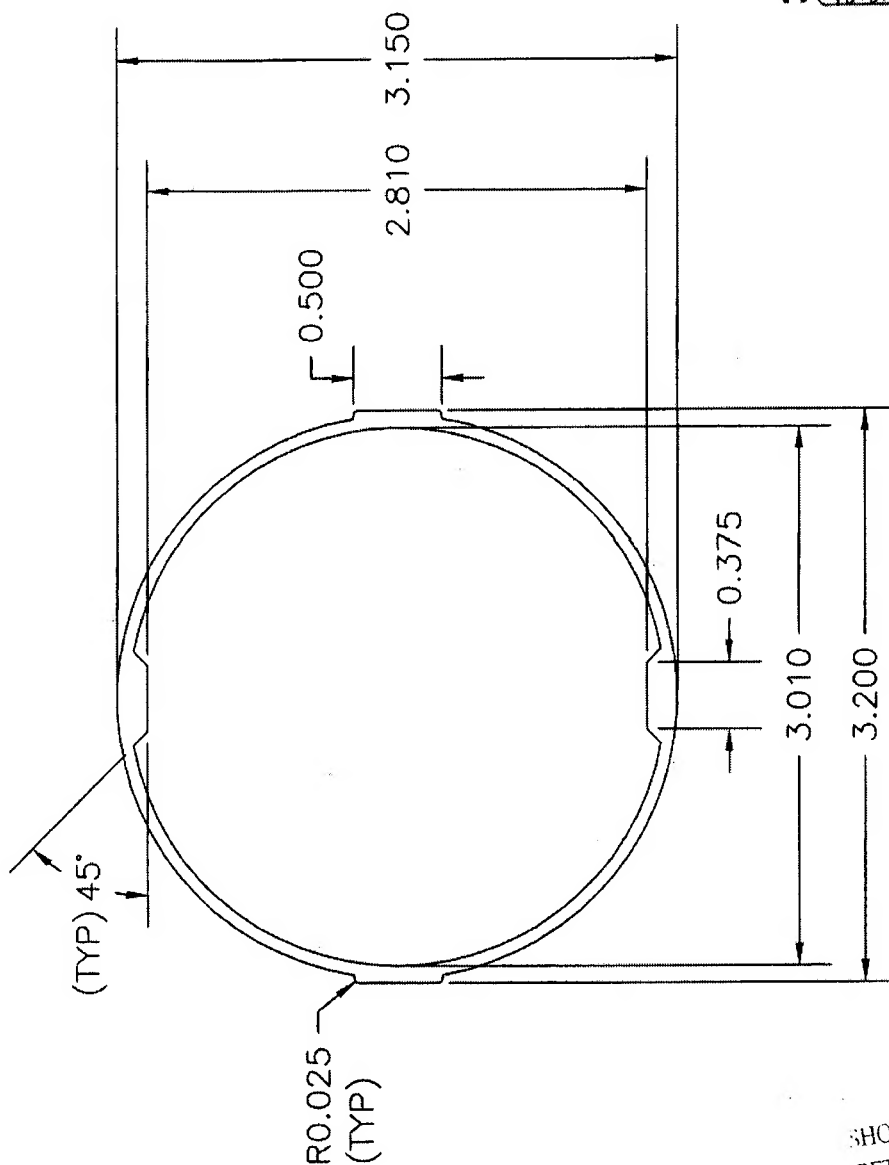
2. BREAK ALL SHARP CORNERS 0.010 MAX.
3. NO TOOLING MARKS.
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
5. ALL DIMENSIONS ARE IN INCHES.

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29985



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DATE 98.08.20	TITLE EXTRUSION		SCALE 1:1

RELEASED
98.8.25 DS



D2600-1

MANUFACTURED WITH CARADON INDALEX DIE # MH-18870

OR BON L DIE # 897121 (PREFERRED CHOICE)

PART NUMBER IS D2600-1-YXX WHERE YXX IS CUT LENGTH IN INCHES (EG. D2600-1-160 IS 160" LONG)

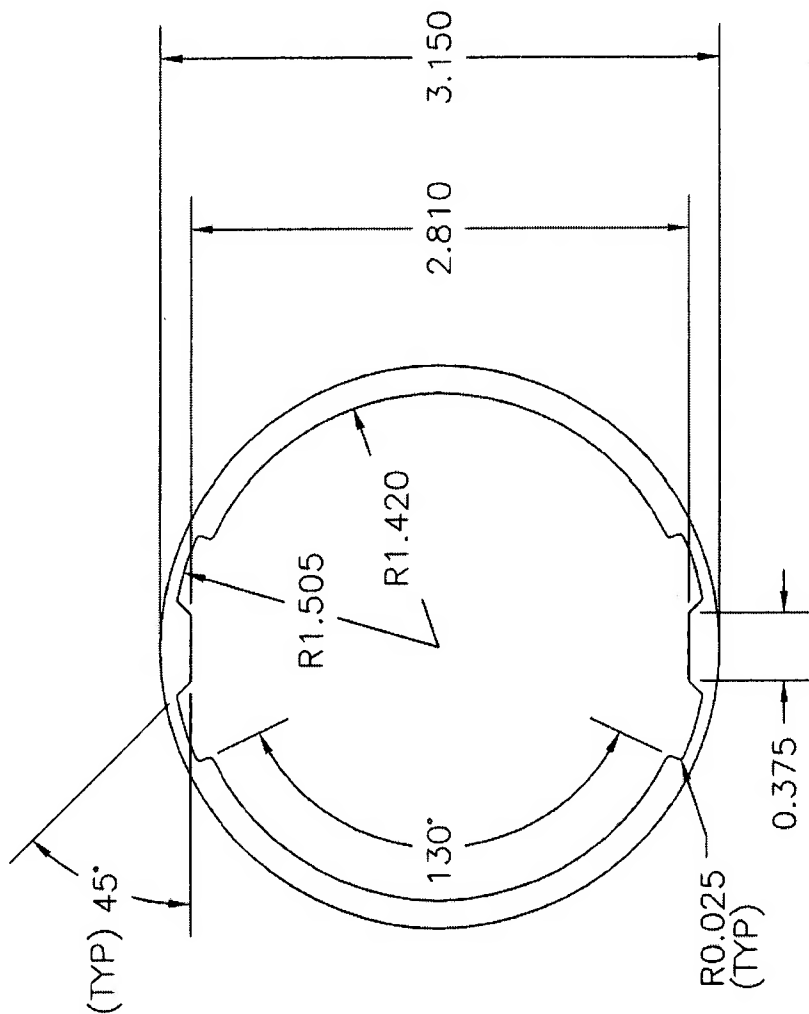
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DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

RELEASED
98.8.25 DS



D2600-3

MANUFACTURED WITH CARADON INDALOX DIE # MH-18859

OR BON L DIE # 897122 (PREFERRED CHOICE)

PART NUMBER IS D2600-3-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-3-120 IS 120" LONG)

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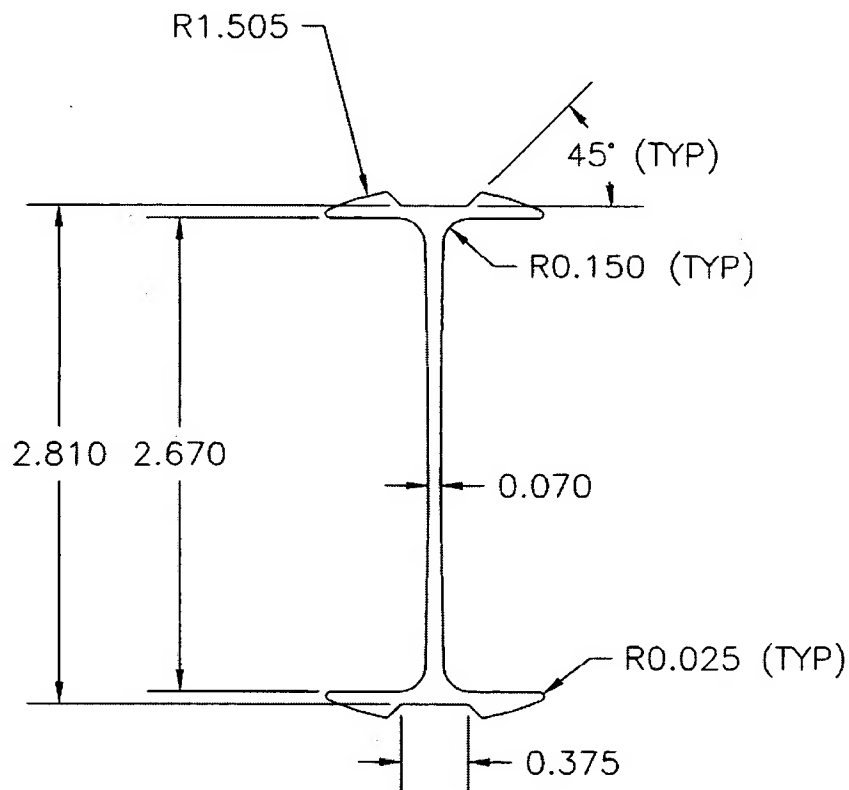


DART



DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. D
KE	[Signature]	D2600	SHEET 4 OF 5
DATE	TITLE	EXTRUSION	SCALE
98.08.20			1:1

RELEASED
98.8.25 BS



D2600-5

MANUFACTURED WITH CARADON INDALEX DIE # MS-18871
PART NUMBER IS D2600-5-XXX WHERE XXX IS CUT LENGTH IN INCHES
(EG. D2600-5-108 IS 108" LONG)

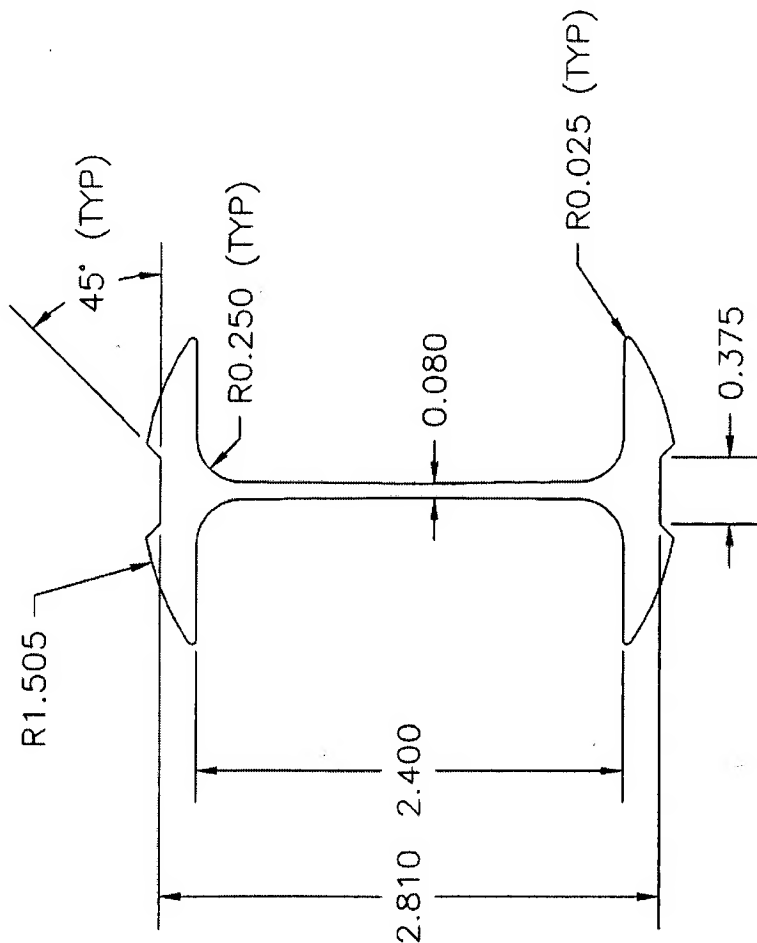


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NO. 29985



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CHECKED <i>RE</i>	APPROVED <i>RE</i>	DRAWING NO. D2600	REV. D SHEET 5 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

RELEASED
98.8.25 DS



D2600-7

MANUFACTURED WITH CARADON INDALEX DIE # MS-18872
PART NUMBER IS D2600-7-XXX WHERE XXX IS CUT LENGTH IN INCHES
(EG. D2600-7-125 IS 125" LONG)

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WORK ORDER
NO. 29985





325 rue Avro
Pointe-Claire QC H9R 5W3

Téléphone (514) 697-5120
Fax-simile (514) 694-8310

Rapport des propriétés mécaniques Mechanical Properties Test Report

Client / Customer : **DART AEROSPACE LTD**
Adresse / Address : **1270 ABERDEEN STREET**
HAWKESBURY ONT,
K6A 1K7

commande Indalex / Indalex order # : **6122003**
bon de commande / Purchase order # : **2722**
de matrice / Die # : **MS 18871** Description : **D-2600-5 Light Duty Web**
Alliage & trempage / Alloy & temper : **6061 T6**
Contrôle / Control # : **36071-1**
Coulée / Cast # : **39544**

	Min.requis Min.required	Résultat actuel Actual results
Tension ultime Ultimate stress (psi)	38 000	47859
Contrainte élastique Yield stress (psi)	35 000	43224
% élongation dans 2" % elongation in 2"	8	12.5
Dureté Rockwell E (hre) Rockwell E Hardness (hre)	88 @ 100	96

Composition chimique typique / Typical chemical composition :

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti
6063	0.20 - 0.60	0.35 Max	0.10 Max	0.10 Max	0.45 - 0.90	0.10 Max	0.10 Max	0.10 Max
6005	0.60 - 0.90	0.35 Max	0.10 Max	0.10 Max	0.40 - 0.60	0.10 Max	0.10 Max	0.10 Max
6005A	0.68 - 0.72	0.15 - 0.27	0.08 - 0.12	0.20 - 0.24	0.48 - 0.52	0.03 Max	0.05 Max	0.08 Max
6061	0.40 - 0.80	0.70 Max	0.15 - 0.40	0.15 Max	0.80 - 1.20	0.04 - 0.35	0.25 Max	0.15 Max
6351	0.7 - 1.3	0.5 Max	0.10 Max	0.40 - 0.80	0.40 - 0.80	—	0.20 Max	0.20 Max

Nous certifions que le matériel fourni rencontre les exigences chimiques telles qu'annoncées par la norme ASTM B-221 et AMS QQA 200/8 ainsi que les exigences de nos procédures de contrôle de qualité.

We hereby certify that the material supplied meets the chemical properties as published by the ASTM B-221 and AMS QQA 200/8 standard and requirements of our quality control procedures.

Sincèrement vôtre,
Yours truly,

date : 2007-01-08

Bruno Morency
Technicien de la qualité
Quality technician

Indalex Limited



INDALEX LIMITED
 325 AVRO Street
 POINTE-CLAIRE, QC H9R 5W3
 TELEPHONE: (514) 697-5120 & (800) 563-5120
 FACSIMILE: (514) 694-8310 & (800) 563-8310

FACSIMILE TRANSMITTAL SHEET

TO: Christina Young	FROM: Bruno Morency Quality Technician
COMPANY: DART AEROSPACE LTD	DATE: 2007/01/08
PAK NUMBER: 1(613) 632-4443	TOTAL NO. OF PAGES INCLUDING COVER: 2
PHONE NUMBER:	SENDER'S REFERENCE NUMBER:
SUBJECT: REPORT	TIME:

☐ URGENT ☐ FOR REVIEW ☐ PLEASE COMMENT ☐ PLEASE REPLY ☐ PLEASE RECYCLE

NOTES/COMMENTS:

Mechanical properties report.

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